

Work Order ID 99424

Monday, April 08, 2013 11:46:54 AM

99424

Page 1

Item ID: D4464-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fuel Tank Assembly

Start Date: 4/8/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/26/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MLS*

Date: *13-05-02* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4464

D

100

Weld per dwg A/R Aluminum rod Batch: *125127* 0.00
125928

100

Large Fab

Memo

0.00

Large Fab

1- weld D4023-3 cap, D3999-11 earth tab and D4008-11 hinge onto D4463-11 as per dwg D4464

2- Weld D4001-1 and D4000-5 onto D4463-1 Top

2- Weld D4463-9 and D4463-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4463-3 aft end as per dwg. locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5-Weld D4463-7 fwd end

PURGE INSIDE OF TANK

13.05.07

Pto →

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: AFH Date: 13/06/07QA Closed: AFH Date: 13/6/06

| | | | | | | | | | | | |
|--|----------|------|-----|--|----------------------------|--|---------------------------|------------------------|---------------------------|--|--|
| Work Order: <u>99424</u> Part No. <u>D4464-041</u> NCR No. <u>13-211</u> | | | | DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input checked="" type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data | 13/05/07 | * | 100 | Found after "take" welding D4462-3 Bar 812 that it causes crack in on D4463-9 R.C. Process / material. | D4 22 09 13.05.07 | Replace cracks: Part | 13-05-30 (DAS 19 9-09) | DAS 27 9-09 13 5 30 | (DAS 16 9-09) 13/05/07 | | |
| Equip/Tooling | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Setup | | | | | | | | | | | |
| Other | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |

| FAULT CATEGORY | | | |
|--|---|---|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

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99424

Page 2

Item ID: D4464-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fuel Tank Assembly

Start Date: 4/8/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/26/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MC*

Date: 13-4-8-

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

13-05-23
~~13-05-27~~DAS
09
2-89

120

Weld per dwg A/R Aluminum rod Batch: 125127
123928 0.00***120***

Large Fab

Memo

0.00

Large Fab

1-Weld top D4463-1 using DT9811 and DT9810

PURGE INSIDE OF TANK

1 φ 13-05-28

123

QC5- Inspect part completeness to step on W/O

0.00

123

QC

Memo

0.00

Quality Control

Pressure Test as per dwg D4464

DAS
27
2-89
13529

1

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Page 3

Item ID: D4464-041

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fuel Tank Assembly

Start Date: 4/8/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/26/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

140

QC9- Inspect visual per QSI004- Fusion Welds

0.00


140

QC

Memo

0.00

Quality Control

1 0 13/05/30 

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

I - brush alodine on tank. No alodine inside

1 13-5-30

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

1X M-f 13/05/30

Work Order ID 99424

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Page 4

Item ID: D4464-041

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fuel Tank Assembly

Start Date: 4/8/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/26/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

170

0.00

170

Powdercoat

0.00

Powder Coating

Memo

Mask prior to powdercoat

POWDER COAT ANSI 61 GREY AS PER DWG AND QSI 005 4.3

Start Time: 7:20

Oven Temperature: 320°F

Finish Time: 7:50

1X d m-f 13/05/31

180

0.00

180

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

1x d ll 13/05/31

m11632a

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Item ID: D4464-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fuel Tank Assembly

Start Date: 4/8/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/26/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

0.00

190

Small Fab

Memo

0.00

Small Fab

1- Mask off area, where access cover is applied

2- Abrade surface with red scotch brite

3- Wipe with clean cloth and wash and wipe

4- Assemble as per dwg and for D4577-041/-3/-5 access panels install wet with
proseal 890

A/R proseal 890 Batch

1124856

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

D4
270
13
B G YES
13/06/08

Work Order ID 99424

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Page 6

Item ID: D4464-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fuel Tank Assembly

Start Date: 4/8/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/26/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: _____

0.00

210

Packaging

Memo

0.00

Packaging

200 102036 SQ

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

MLW 13-06-05

ME
13-6-4

Picklist Print

Monday, April 08, 2013 11:46:48 AM

Page 1

Work Order ID: 99424
Parent Item: D4464-041
Parent Item Name: Fuel Tank Assembly

Start Date: 4/8/2013
Start Qty: 1.00

Required Date: 4/26/2013
Required Qty: 1.00

Comments: IPP REV:A 11.11.23 NEW ISSUE DD VERF:EC IPP REV:B 12.03.08 AS PER
DWG REV:B DD VERF:EC IPP REV:C 12.04.24 ECN 12-571 DD VERF:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D3997-5 Placard | | Manufactured | No | | | 190 | Each | 88.0000 | 2 | 2 | SP | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST243 | | 88 | | | | | | | |
| | | | | 72611 | | 75 | | | | | | | |
| | | | | 81028 | | 4 | | | 2x | | | | |
| | | | | 83650 | | 2 | | | | | | | |
| | | | | 87530 | | 7 | | | | | | | |
| D3997-11 Placard | | Manufactured | No | | | 190 | Each | 5.0000 | 1 | 1 | SP | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST243 | | 5 | | | | | | | |
| | | | | 82957 | | 5 | | | 1x | | | | |
| D3997-17 Placard | | Manufactured | No | | | 190 | Each | 7.0000 | 1 | 1 | SP | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST243 | | 7 | | | | | | | |
| | | | | 82958 | | 7 | | | 1x | | | | |
| D3997-29 Placard | | Manufactured | No | | | 190 | Each | 6.0000 | 1 | 1 | SP | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST243 | | 6 | | | | | | | |
| | | | | 80845 | | 6 | | | 1x | | | | |
| D3997-43 Placard | | Manufactured | No | | | 190 | Each | 6.0000 | 1 | 1 | SP | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST243 | | 6 | | | | | | | |
| | | | | 82960 | | 6 | | | 1x | | | | |

SP B-6-2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | |
|--|---|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|--|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data <input type="checkbox"/> | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | |

FAULT CATEGORY

| | | | | |
|---|---|---|--|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|---|---|---|--|---|

Picklist Print

Monday, April 08, 2013 11:46:50 AM

Page 2

Work Order ID: 99424

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 4/8/2013

Required Date: 4/26/2013

Start Qty: 1.00

Required Qty: 1.00

D3999-7 Manufactured No 100 Each 3.0000 1 1
Corner

| Location | Loc Qty | Loc Code |
|------------------------|---------|----------|
| WA003 <u>B100145</u> ① | 3 | |
| 71695 | 1 | |
| 86021 | 2 | |

13-05-07

D3999-9 Manufactured No 100 Each 2.0000 1 1
Angle

| Location | Loc Qty | Loc Code |
|---------------------|---------|----------|
| WA003 <u>B99497</u> | 2 | |
| 82545 | 1 | |
| 86022 | 1 | |

13-05-06

D3999-11 Manufactured No 100 Each 10.0000 1 1
Earth Tab

| Location | Loc Qty | Loc Code |
|----------------|---------|----------|
| WA003 | 10 | |
| <u>84161</u> ① | 10 | |

13-05-07

D4000-1 Manufactured No 100 Each 9.0000 1 1
Fuel Supply Fitting

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA003 | 9 | |
| 83811 | 1 | |
| 96197 | 8 | |

13-05-10

D4000-5 Manufactured No 100 Each 7.0000 1 1
Fuel Tank Vent Fitting

| Location | Loc Qty | Loc Code |
|--------------|---------|----------|
| WA003 | 7 | |
| <u>95633</u> | 7 | |

14 13-05-06

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Shop Packet Print

Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|------------------------------------|--|---|---|--------------------------|--|------------------------|---------------------|---|--|--|------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube <input type="checkbox"/></td> <td style="width: 15%;">Crosstube <input type="checkbox"/></td> <td style="width: 15%;">Water Jet <input type="checkbox"/></td> <td style="width: 15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | | | | | | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | | | | | | | | | | | | | | | | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | | | | | | | | | | | | | | | | | | |

Picklist Print

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Page 3

Work Order ID: 99424
Parent Item: D4464-041
Parent Item Name: Fuel Tank Assembly

Start Date: 4/8/2013

Required Date: 4/26/2013

Start Qty: 1.00

Required Qty: 1.00

D4000-9
Grommet

Manufactured

100 Each 22.0000 3 3

113.05.06

Location Loc Qty Loc Code

SL083 18
96195 18
4
2
2

3

D4000-045
Fuel Pickup Fitting Assembly

Manufactured

100 Each 3.0000 1 1

113.05.24

Location Loc Qty Loc Code

WA003 3
720 1
90582

1

D4008-11
Hinge Half

Manufactured

No

Each 4.0000 1 1

113.05.02

Location Loc Qty Loc Code

WA003 399706 4
80037 1
95645 3

1+1

1 good
1 scrap

D4008-041
Fuel Filler Splash Guard Assembly

Manufactured

No

190 Each 1.0000 1 1

SB 13/04/03

Location Loc Qty Loc Code

ST242A 1
97598

B 99803

D4023-3
Cap and Flange

Manufactured

No

190 Each 8.0000 1 1

113.05.06

Location Loc Qty Loc Code

WA003 3100186 8
81898 1
84422 7

21+1

1 scrap
1 good

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Shop Packet Print

Page 3

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | |
|--|---|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|--|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data <input type="checkbox"/> | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | |

FAULT CATEGORY

| | | | | |
|---|---|---|--|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Oil | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|---|---|---|--|---|

Picklist Print

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Page 4

Work Order ID: 99424

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 4/8/2013

Required Date: 4/26/2013

Start Qty: 1.00

Required Qty: 1.00

D4025-5 Manufactured No 190 Each 2.0000 1 1
Fuel Quantity Sender

Location Loc Qty Loc Code

ST141 2

84421 2

D4057-1 Manufactured No 100 Each 25.0000 3 3
Retaining Ring

Location Loc Qty Loc Code

WA003 25

83656 1

95809 24

D4062-041 Manufactured No 190 Each 3.0000 1 1
Tank Support Assembly

Location Loc Qty Loc Code

WA003 3

86024 3

D4124-1 Manufactured No 100 Each 15.0000 4 4
Tab

Location Loc Qty Loc Code

WA 100079 12

97571 12

WA003 3

83824 1

93815 2

D4125-1 Manufactured No 100 Each 4.0000 1 1
Sump

Location Loc Qty Loc Code

ST150 599890 3

90234 3

WA003 1

83825 1

B99745 SP

113-05-06

113-05-28

113-05-23

113-05-02

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Shop Packet Print

Page 4

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | |
|--|---|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Operator | | | | | | | | | |
| Material | | | | | | | | | |
| Setup | | | | | | | | | |
| Other | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| Landing Gear | General | Other |
|---|---|--|
| <input type="checkbox"/> Bending | <input type="checkbox"/> Bend | <input type="checkbox"/> Grain |
| <input type="checkbox"/> Centre Not Concentric to O/S | <input type="checkbox"/> BOM/Route | <input type="checkbox"/> Hardware |
| <input type="checkbox"/> Cracks | <input type="checkbox"/> Broken/Damaged | <input type="checkbox"/> Inspection Incomplete |
| <input type="checkbox"/> Crushed/Crimped | <input type="checkbox"/> Burrs | <input type="checkbox"/> Instructions Incomplete/Unclear |
| <input type="checkbox"/> Cuffs | <input type="checkbox"/> Contamination | <input type="checkbox"/> Maintenance |
| <input type="checkbox"/> Heat Treat | <input type="checkbox"/> Countersink | <input type="checkbox"/> Mislabeled |
| <input type="checkbox"/> Inspection Strip in Tube | <input type="checkbox"/> Cut Too Short | <input type="checkbox"/> Misread |
| <input type="checkbox"/> Ripples in Bend | <input type="checkbox"/> Drill Holes | <input type="checkbox"/> Offset |
| <input type="checkbox"/> Torque Waves in Extrusion | <input type="checkbox"/> Drawing | <input type="checkbox"/> Out of Calibration |
| <input type="checkbox"/> Turning Sequence | <input type="checkbox"/> Finish | <input type="checkbox"/> Out of Sequence |
| <input type="checkbox"/> Wave/Twist in Tube | <input type="checkbox"/> Folio | <input type="checkbox"/> Outside Dimensions |
| | | <input type="checkbox"/> Ovalized |
| | | <input type="checkbox"/> Over/Under tolerance |
| | | <input type="checkbox"/> Part Incorrect |
| | | <input type="checkbox"/> Part Lost/Missing |
| | | <input type="checkbox"/> Part Moved |
| | | <input type="checkbox"/> Positioned Wrong |
| | | <input type="checkbox"/> Power Loss/Surge |
| | | <input type="checkbox"/> Pressure/Forced |
| | | <input type="checkbox"/> Temperature/Cure |
| | | <input type="checkbox"/> Weld |
| | | <input type="checkbox"/> Wrong Stock Pulled |
| | | <input type="checkbox"/> Other |

Picklist Print

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Page 5

Work Order ID: 99424

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 4/8/2013

Required Date: 4/26/2013

Start Qty: 1.00

Required Qty: 1.00

D4125-3 Manufactured No 100 Each 4.0000 1 1
End

11.05.02

| Location | Loc Qty | Loc Code |
|--------------|---------|----------|
| WA003 399891 | 4 | |
| 83826 | 1 | |
| 90235 | 3 | |

D4404-3 Manufactured No 100 Each 3.0000 1 1
Cushion, Side

31000808P

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST143 | 3 | |
| 95713 | 3 | |

D4404-5 Manufactured No 100 Each 9.0000 4 4
Cushion, Fwd

3991568P

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST143 | 1 | |
| 87501 | 1 | |
| ST144 | 8 | |
| 97564 | 8 | |

D4462-1 Manufactured No 100 Each 2.0000 1 1
Baffle

| Location | Loc Qty | Loc Code |
|--------------|---------|----------|
| WA003 399783 | 2 | |
| 89923 | 2 | |

11.05.06

D4462-3 Manufactured No 100 Each 2.0000 1 1
Baffle

| Location | Loc Qty | Loc Code |
|--------------|---------|----------|
| WA003 399804 | 2 | |
| 89924 | 2 | |

11.05.06

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Shop Packet Print

Page 5

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | |
|--|---|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Operator | | | | | | | | | |
| Material | | | | | | | | | |
| Setup | | | | | | | | | |
| Other | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| Landing Gear | General | Other |
|---|---|--|
| <input type="checkbox"/> Bending | <input type="checkbox"/> Bend | <input type="checkbox"/> Grain |
| <input type="checkbox"/> Centre Not Concentric to O/S | <input type="checkbox"/> BOM/Route | <input type="checkbox"/> Hardware |
| <input type="checkbox"/> Cracks | <input type="checkbox"/> Broken/Damaged | <input type="checkbox"/> Inspection Incomplete |
| <input type="checkbox"/> Crushed/Crimped | <input type="checkbox"/> Burrs | <input type="checkbox"/> Instructions Incomplete/Unclear |
| <input type="checkbox"/> Cuffs | <input type="checkbox"/> Contamination | <input type="checkbox"/> Maintenance |
| <input type="checkbox"/> Heat Treat | <input type="checkbox"/> Countersink | <input type="checkbox"/> Mislabeled |
| <input type="checkbox"/> Inspection Strip in Tube | <input type="checkbox"/> Cut Too Short | <input type="checkbox"/> Misread |
| <input type="checkbox"/> Ripples in Bend | <input type="checkbox"/> Drill Holes | <input type="checkbox"/> Offset |
| <input type="checkbox"/> Torque Waves in Extrusion | <input type="checkbox"/> Drawing | <input type="checkbox"/> Out of Calibration |
| <input type="checkbox"/> Turning Sequence | <input type="checkbox"/> Finish | <input type="checkbox"/> Out of Sequence |
| <input type="checkbox"/> Wave/Twist in Tube | <input type="checkbox"/> Folio | <input type="checkbox"/> Outside Dimensions |
| | | <input type="checkbox"/> Ovalized |
| | | <input type="checkbox"/> Over/Under tolerance |
| | | <input type="checkbox"/> Part Incorrect |
| | | <input type="checkbox"/> Part Lost/Missing |
| | | <input type="checkbox"/> Part Moved |
| | | <input type="checkbox"/> Positioned Wrong |
| | | <input type="checkbox"/> Power Loss/Surge |
| | | <input type="checkbox"/> Pressure/Forced |
| | | <input type="checkbox"/> Temperature/Cure |
| | | <input type="checkbox"/> Weld |
| | | <input type="checkbox"/> Wrong Stock Pulled |
| | | <input type="checkbox"/> Other |

Picklist Print

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Page 6

Work Order ID: 99424

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 4/8/2013

Required Date: 4/26/2013

Start Qty: 1.00

Required Qty: 1.00

D4463-041
Tank Top Assembly

Manufactured No

120 Each 5.0000

1 1

113.05.06

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA003 | 5 | |
| 84364 | 1 | |
| 92263 | 4 | |

1 good
1 scrap

D4463-3
Tank Aft End

Manufactured No

100 Each 3.0000

1 1

113.05.10

| Location | Loc Qty | Loc Code |
|----------------|---------|----------|
| WA003 | 3 | |
| <i>B100084</i> | 3 | |
| 89919 | 3 | |

1

D4463-5
Tank Upper Cut Out

Manufactured No

100 Each 2.0000

1 1

113.05.06

| Location | Loc Qty | Loc Code |
|---------------|---------|----------|
| WA003 | 2 | |
| <i>399498</i> | 1 | |
| 76906 | 1 | |
| 83834 | 1 | |

1 scrap
1 good

D4463-7
Tank Fwd End

Manufactured No

100 Each 2.0000

1 1

113.05.28

| Location | Loc Qty | Loc Code |
|---------------|---------|----------|
| WA003 | 2 | |
| <i>399827</i> | 2 | |
| 89918 | 2 | |

1

D4463-9
Tank Back

Manufactured No

100 Each 3.0000

1 1

113.05.02

| Location | Loc Qty | Loc Code |
|----------------|---------|----------|
| WA003 | 3 | |
| <i>B100350</i> | 1 | |
| <i>B100085</i> | 3 | |
| 89920 | 3 | |

1 scrap

D4463-11
Tank Front

Manufactured No

100 Each 3.0000

1 1

113.05.02

| Location | Loc Qty | Loc Code |
|----------------|---------|----------|
| WA003 | 3 | |
| <i>B100082</i> | 3 | |
| 89921 | 3 | |
| <i>B101349</i> | | |

1 scrap
1 good

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Shop Packet Print

Page 6

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | |
|--|---|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|--|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data <input type="checkbox"/> | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | |

FAULT CATEGORY

| | | |
|---|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|---|---|--|

Picklist Print

Monday, April 08, 2013 11:46:53 AM

Page 7

Work Order ID: 99424

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 4/8/2013

Required Date: 4/26/2013

Start Qty: 1.00

Required Qty: 1.00

D4463-13

Tank Bottom

Manufactured

No

190

Each

6.0000

1

1

113.05.02

Location

Loc Qty

Loc Code

WA003

6

82237

2

83831

1

89922

3

AN3H5A

Bolt

Purchased

No

190

Each

59.0000

5

5

SP

Location

Loc Qty

Loc Code

ST350

59

122800

9

124805

50

5x

SP

MS21042L3

Nut

Purchased

No

190

Each

5,099.0000

4

4

Location

Loc Qty

Loc Code

FP001

3

122141

3

GA

135

122452

135

ST314

268

117885

32

119017

55

119075

138

123265

43

ST506

4693

123900

1036

124291

3657

4x

MS35206-266

Screw

Purchased

No

190

Each

166.0000

4

4

SP 13-6-28

Location

Loc Qty

Loc Code

ST289

166

119850

66

123168

100

4x

Monday, April 08, 2013 11:46:54 AM

Shop Packet Print

Page 7

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | |
|--|---|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|--|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data <input type="checkbox"/> | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | |

FAULT CATEGORY

| | | |
|---|---|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions |
| | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge |
| | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

Picklist Print

Monday, April 08, 2013 11:46:54 AM

Page 9

Work Order ID: 99424

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 4/8/2013

Required Date: 4/26/2013

Start Qty: 1.00

Required Qty: 1.00

D4577-041

Manufactured

No

190

Each

4.0000

1

1

Fwd Access Panel Assembly

Location

Loc Qty

Loc Code

ST142

4

95759

2

97512

2

ES 13/05/31

**AN3-6A* *(D4 23 88)* *4x*
13.06.04

M124296

ES 13/06/04

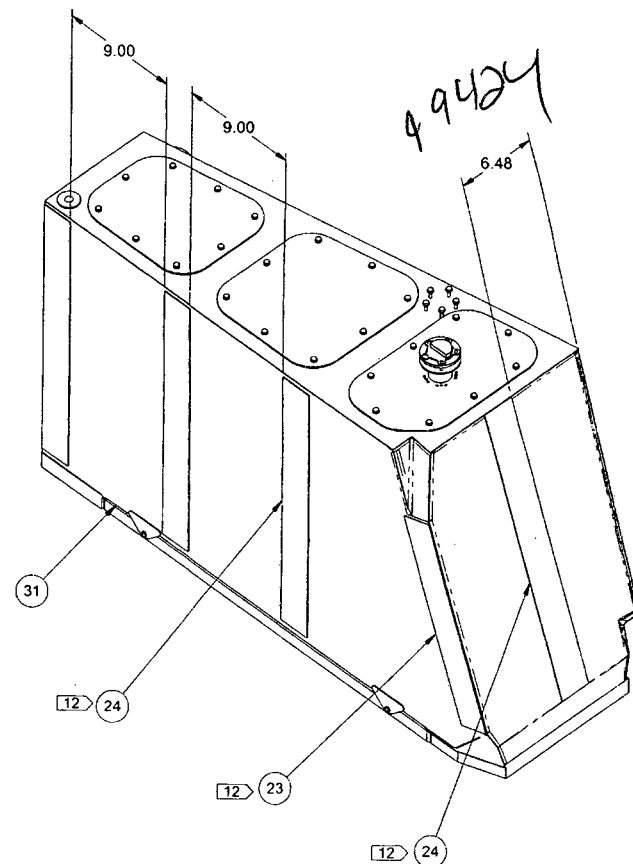
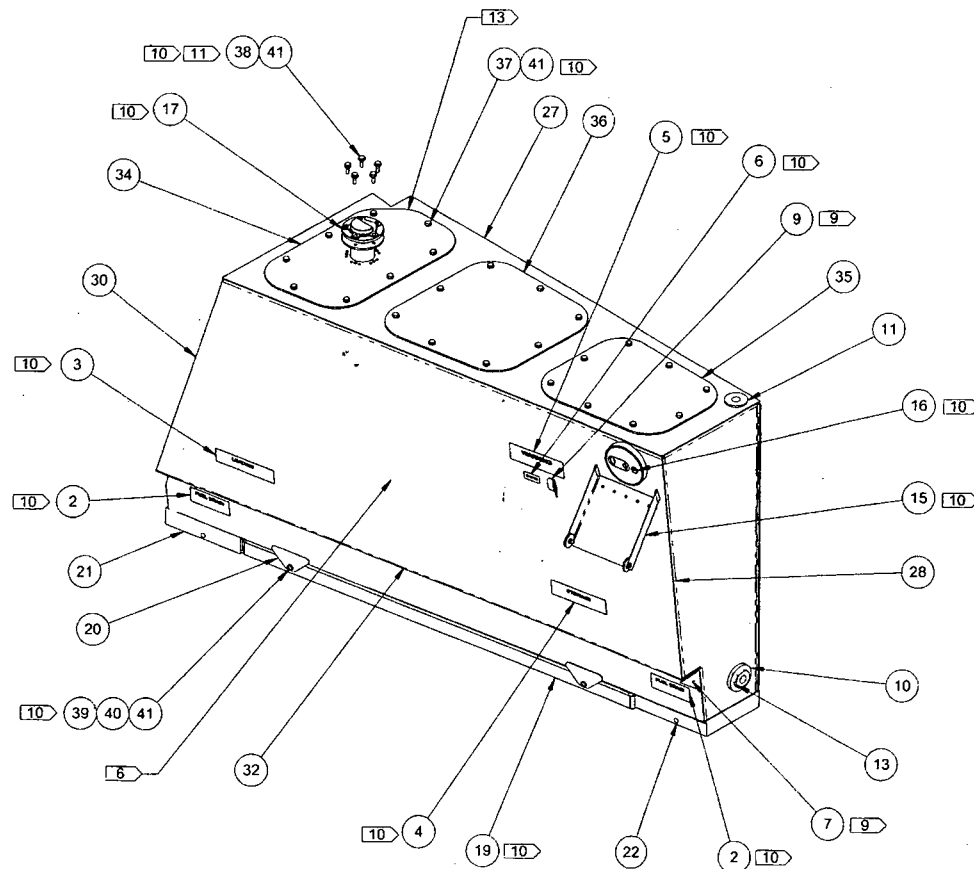
| ITEM NO. | QTY. -041 | PART NUMBER | DESCRIPTION |
|----------|--------------|---------------|------------------------------------|
| 1 | X | D4464-041 | FUEL TANK ASSEMBLY |
| 2 | 2 | D3997-5 | PLACARD "AUX FUEL DRAIN" |
| 3 | 1 | D3997-11 | PLACARD "LOADING" |
| 4 | 1 | D3997-17 | PLACARD "STOWAGE" |
| 5 | 1 | D3997-29 | PLACARD "WARNING" |
| 6 | 1 | D3997-43 | PLACARD "EARTH" |
| 7 | 1 | D3999-7 | CORNER |
| 8 | 1 | D3999-9 | ANGLE |
| 9 | 1 | D3999-11 | EARTH TAB |
| 10 | 1 | D4000-1 | FUEL SUPPLY FITTING |
| 11 | 1 | D4000-5 | FUEL TANK VENT FITTING |
| 12 | 3 | D4000-9 | GROMMET |
| 13 | 1 | D4000-045 | FUEL PICK UP AND STRAINER ASSEMBLY |
| 14 | 1 | D4008-11 | TANK HINGE HALF |
| 15 | 1 | D4008-041 | FUEL FILLER SPLASH GUARD ASSEMBLY |
| 16 | 1 | D4023-3 | FUEL CAP |
| 17 | 1 | D4025-5 | FUEL SENDER |
| 18 | 3 | D4057-1 | RETAINING RING |
| 19 | 1 | D4062-041 | TANK SUPPORT ASSEMBLY |
| 20 | 4 | D4124-1 | TAB |
| 21 | 1 | D4125-1 | FWD SEDIMENT BOWL |
| 22 | 1 | D4125-3 | AFT SEDIMENT BOWL |
| 23 | 1 | D4404-3 | CUSHION, SIDE |
| 24 | 4 | D4404-5 | CUSHION, FWD |
| 25 | 1 | D4462-1 | BAFFLE |
| 26 | 1 | D4462-3 | BAFFLE |
| 27 | 1 | D4463-041 | TOP TANK ASSEMBLY |
| 28 | 1 | D4463-3 | TANK AFT END |
| 29 | 1 | D4463-5 | TANK UPPER CUT OUT |
| 30 | 1 | D4463-7 | TANK FORWARD END |
| 31 | 1 | D4463-9 | TANK BACK |
| 32 | 1 | D4463-11 | TANK FRONT |
| 33 | 1 | D4463-13 | TANK BOTTOM |
| 34 | 1 | D4577-041 | FWD ACCESS PANEL ASSEMBLY |
| 35 | 1 | D4577-1 | REAR ACCESS PANEL |
| 36 | 1 | D4577-3 | MIDDLE ACCESS PANEL |
| 37 | 24 | AN3-4A | BOLT |
| 38 | 5 | AN3H5A | BOLT |
| 39 | 4 | MS21042L3 | NUT |
| 40 | 4 | MS35207-266 | SCREW |
| 41 | 37 | NAS1149D0363J | WASHER |

#99424

RELEASED
2012-05-09
JMS

| | | | |
|------------|--|----|----------|
| D | ADDED NOTE RE HAND FORMING D4124-1, ZN A8-4. | DC | 12.05.02 |
| C | UPDATED -041 WITH RE-DESIGNED D4463-11/13 REV. C PARTS, ZN B6-2. UPDATED -041 WITH RE-DESIGNED D4577-041/3/5 PARTS, ZN C8-2. | DC | 12.03.27 |
| B | UPDATED -041 WITH RE-DESIGNED PARTS, REMOVED D4463-13. ADDED D4577-041/1/5 ACCESS PANELS, ZN C6-2. | DC | 11.12.14 |
| A | NEW ISSUE, REF PAR11-117 & CAR 11-54. | DC | 11.10.19 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | JSC | | |
| CHECKED | FE | | |
| MFG. APPR. | FE | | |
| APPROVED | 149 | | |
| DE APPR. | 149 | | |
| DATE | 12.05.02 | | |

| | |
|--|------------------------|
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWING NO. D4464 | REV. D SHEET 1 OF 5 |
| TITLE TANK ASSEMBLY | SCALE NTS |
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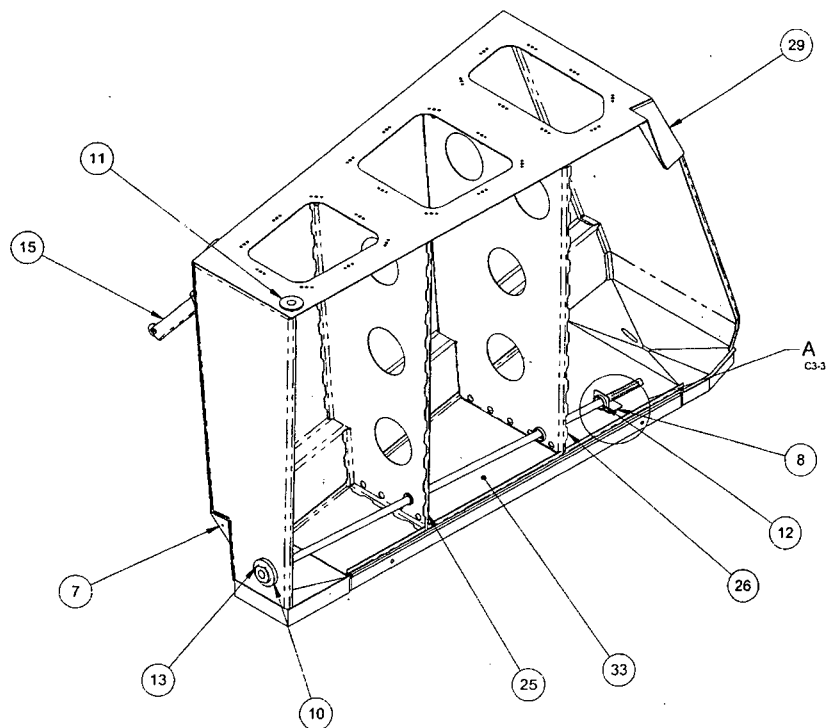
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: TOUCH UP, CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-141" USING D2729-1 RED DECAL
- 7) WEIGHT: 35.81 lbs
- 8) CAP ALL TANK ACCESS POINTS AND PRESSURE TEST TANK PER QSI 038 4.3. VERIFY NO LEAKS
- 9) MASK PRIOR TO POWDER COAT
- 10) INSTALL AFTER POWDER COAT
- 11) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 12) INSTALL CUSHIONS AFTER POWDER COAT USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED
- 13) INSTALL D4577-041/-3/-5 ACCESS PANELS WET WITH PROSEAL 890.

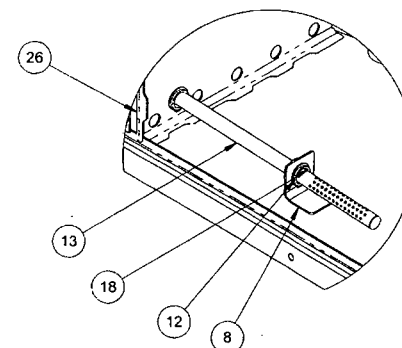
D4464-041 FUEL TANK ASSEMBLY

RELEASED
2012-05-09

| | | | |
|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | DC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | DC | DRAWING NO. D4464 | REV. D |
| MFG. APPR. | DC | | SHEET 2 OF 5 |
| APPROVED | DC | TITLE TANK ASSEMBLY | SCALE NTS |
| DE APPR. | DC | | |
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D4464-041 FUEL TANK ASSEMBLY
D4463-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL

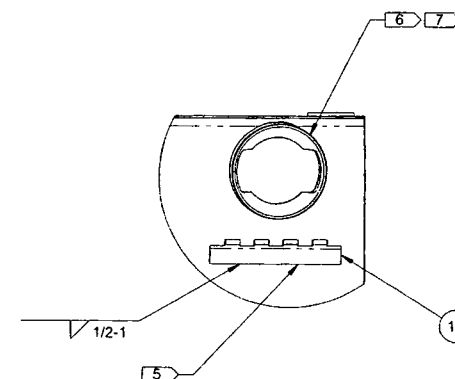
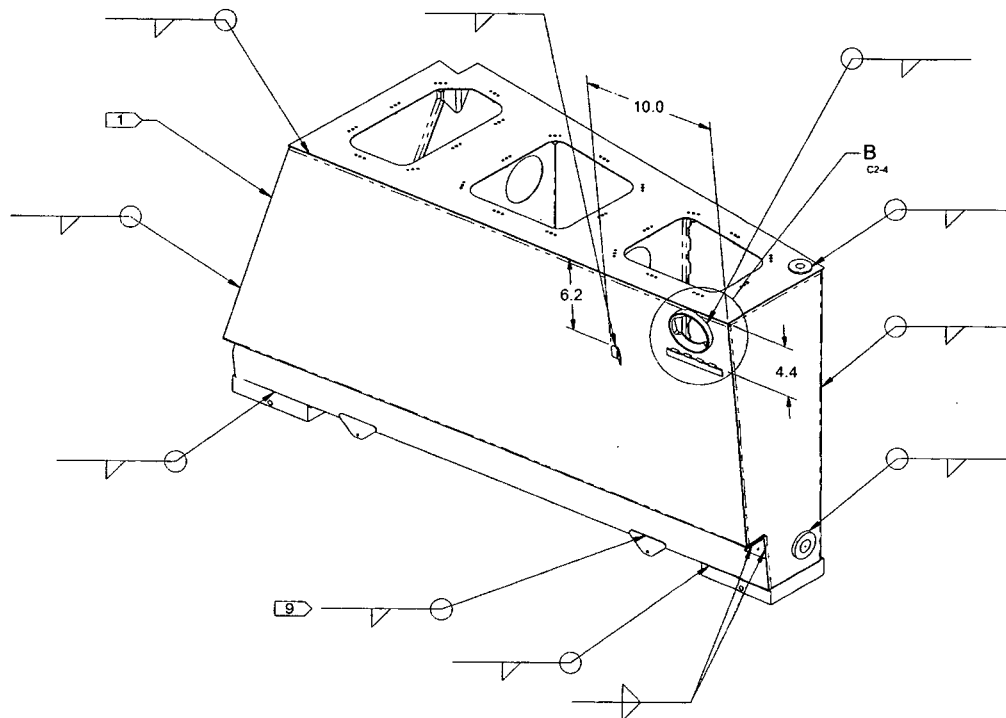


DETAIL A
ROTATED FOR CLARITY
SCALE 2X

B6-3

RELEASED
 2012-05-09
WMP

| | | | |
|------------|-----------------|---|--------|
| DESIGN | <i>JS</i> | DART AEROSPACE LTD | |
| DRAWN | <i>JS</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>JS</i> | DRAWING NO. D4464 | REV. D |
| MFG. APPR. | <i>JS</i> | SHEET 3 OF 5 | |
| APPROVED | <i>JS</i> | TITLE | SCALE |
| DE APPR. | <i>JS</i> | TANK ASSEMBLY | NTS |
| DATE | 12.05.02 | <small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |



DETAIL B
ROTATED FOR CLARITY
SCALE 2X

RELEASED
2012-05-09
MD

D4464-041 FUEL TANK ASSEMBLY
WELDING DETAIL

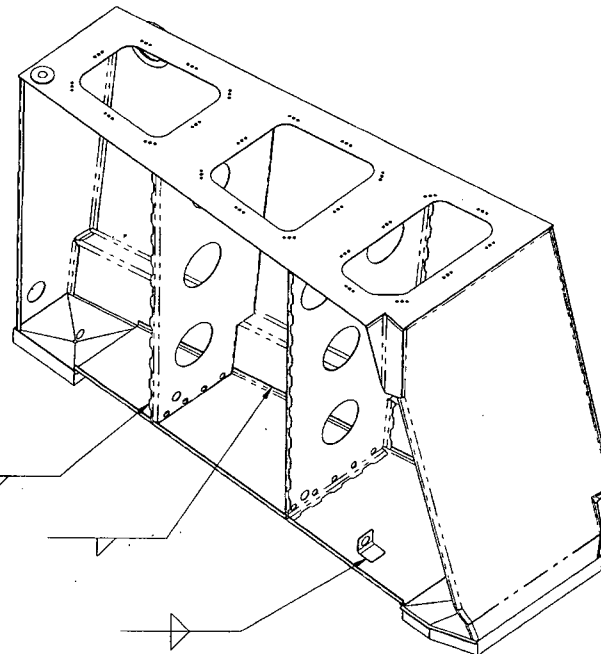
NOTES:

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
- END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
- ALL SWarf REMOVED
- 3) ACCEPTABLE TO DRILL 6 (TYP) $\phi 0.312$ HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 4) ACCEPTABLE TO DRILL 7 (TYP) $\phi 0.312$ HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) CENTER HINGE BELOW FUEL CAP FLANGE
- 6) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 7) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK
- 8) WELD PER DART QSI 004
- 9) USE THE D4062-041 TANK SUPPORT ASSEMBLY TO POSITION THE D4124-1 TABS BEFORE WELDING;
D4124-1 TABS MAY BE HAND FORMED AS REQUIRED TO FIT D4062-041 ASSEMBLY BEFORE WELDING.



| | | | |
|------------|----------|---|--------------|
| DESIGN | JE | DART AEROSPACE LTD | |
| DRAWN | BC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JE | DRAWING NO. | REV. D |
| MFG. APPR. | JE | D4464 | SHEET 4 OF 5 |
| APPROVED | MD | TITLE | SCALE |
| DE APPR. | MD | TANK ASSEMBLY | NTS |
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WELD ALL TABS



D4464-041 FUEL TANK ASSEMBLY
WELDING DETAIL

99424
RELEASED
2012-05-09
MH

| | | | |
|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | BC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | BC | DRAWING NO. | REV. D |
| MFG. APPR. | BC | D4464 | SHEET 5 OF 5 |
| APPROVED | MH | TITLE | SCALE |
| DE APPR. | MH | TANK ASSEMBLY | NTS |
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